

Work Order ID 57518

April 8, 2010 7:21:16 AM



Page 1

Item ID: D2281

Accept



Setup Start



Revision ID:

Item Name: Jack Saddle

Stop



Start Date: 4/08/10 Start Qty: 40.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2281

Rev G

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2281

☐ Dwg Rev:

G

☐ Prog Rev:

G

☐ 2-

Debur if necessary

304 .080

HB B10-4-12

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-4-12

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

51064/13

cont'd
(X40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Debur

0.00

0.00

0.00

0.00

0.00

0.00

0.00

140



Brake NC

Brake NC

NC BRAKE

Memo

Form as per D2281 using D2281-T2

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

N/A

SB 10/04/13

8/06/14

40

40

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Page 3

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Start Date: 4/08/10 Start Qty: 40.00

Required Date: 4/16/10 Req'd Qty: 40.00

Reference:



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____

QC: _____ Date: _____ SPC (Y/N): _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location *261*

0.00



Packaging

Memo

0.00

Packaging

*16-4-**15**SP**400*

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/04/19**MF 10-4-16*

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Picklist Print

April 8, 2010 7:21:16 AM

Page 1

Work Order ID: 57518

Parent Item: D2281

Parent Item Name: Jack Saddle

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM
IPP: rev B ☐ 06.07.17 ☐ waterjet ☐ EC ☐

Start Date: 4/08/10

Required Date: 4/16/10

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S14GA		Purchased	No			100	sf	143.9608	5.2632			



304SS sheet .080



1810-4-12

Warehouse
Location

Main Warehouse
MAT20
113295

Loc Qty

Loc Code

143.9608
143.9608

113295

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DART AEROSPACE LTD		Work Order:	57581
Description: Jack Saddle		Part Number:	D2281
Inspection Dwg: D2281 Rev: G		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

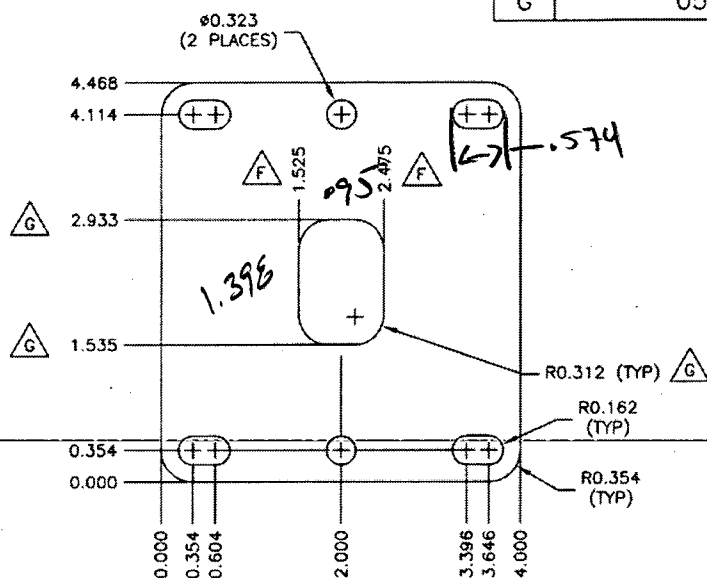
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.470	✓			
4.114	+/-0.010	4.112	✓			
2.933	+/-0.010	2.935	✓			
1.535	+/-0.010	1.536	✓			
0.354	+/-0.010	.355	✓			
0.354	+/-0.010	.356	✓			
0.604	+/-0.010	.604	✓			
2.000	+/-0.010	1.999	✓			
3.396	+/-0.010	3.399	✓			
3.646	+/-0.010	3.646	✓			
4.000	+/-0.010	4.007	✓			
1.525	+/-0.010	1.525	✓			
2.475	+/-0.010	2.477	✓			
Ø0.323	+0.006/-0.001	.325	✓			
0.080	+/-0.010	.074	✓			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-4-12	Date: 10/6/13	Date:	N/A

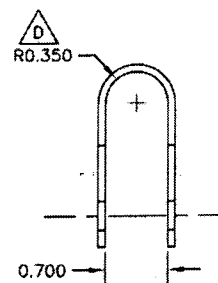
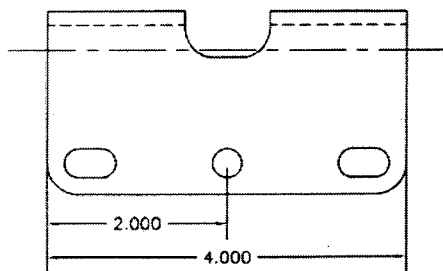
Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	



DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. C SHEET 1 OF 1
DATE 05.06.07	TITLE JACK SADDLE	SCALE 1:2	
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	



FLAT LAYOUT



D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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